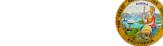
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

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Contract #: 04-0120F4

Cty: SF/Ala Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-010919 Address: 333 Burma Road **Date Inspected:** 15-Dec-2009

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: Tower Components**

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW repair welding of weld joint NSTL4-SPSA4-15-1A located inside PCMK north tower, lift 4,skins B/C corner, inside splice plate. Welder was identified as 053869. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-1G(1F)-repair as listed on the ZPMC weld repair report #T-WR2796 presented to this QA Inspector by QC Gao Zhi Chun.

FCAW welding of weld joint corner assemblies to be located inside various towers, lift 4, skins B/C, C/D, A/E corners, at double diaphragms. Welders were identified as 0540169, 052075. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-2132. Also at this location and appearing to be monitoring the welding operation was ABF Representative Li Nan.

SMAW repair welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4,skin B to skin C.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Welder was identified as 056200. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-345-SMAW-4G(4F)-repair as listed on the unnumbered ZPMC weld repair report presented to this QA Inspector by QC1.

Bay 11

This QA Inspector randomly observed the following work in progress in Bay 11:

Drilling previously pilot-scored holes into PCMK west tower, lifts 2 and 3, skin plates B and C at the lift 2/3 joint, from the outside in. No template was being used.

SAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 138M and 140M elevation. Welder was identified as 202756. ZPMC QC was identified as CWI Liu Xiaozhong (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Shao Hailang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2221-C-L2a-S. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Luo Lai Quan and Wang Liang Hua.

FCAW welding of weld joint WSTL4-2B/L-59A located outside PCMK west tower, lift 4, skin A to skin E, between approximately 125M and 127M elevation. Welder was identified as 053486. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Shao Hailang, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2221-C-L2a-S. Also at this location and appearing to be monitoring the welding operation were ABF Representatives Luo Lai Quan and Wang Liang Hua.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer